

Work Order ID 86981

86981

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July-10-12 9:13:06 AM

Item ID: D2956 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Window Frame
 Start Date: 7/10/12 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 8/17/12 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/07/11 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2956 | Rev C | | | | | | | | |

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2956 Dwg Rev: C Prog Rev: C 2-
 Deburr if necessary

5052. 040

BZ-7-26

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

BZ-7-28

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

SMB
12.7.25

DAS
16
12/14/25

④

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |
| 140 | White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| Powdercoat | Memo | 0.00 | | | | | | | |
| Powder Coating | START TIME: 9:30 OVEN TEMPERATURE: | | | | | | | | |
| | 3200F FINISH TIME: 15:00 | | | | | | | | |
| 150 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

m121841

4 7/27 12-7-26

4 X 12/27/27

4 12-7-27

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | Identify as per dwg & Stock Location: _____ | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| Packaging | Memo 50213 | 0.00 | | | | | | | 12/17/30 (4) |
| Packaging | | | | | | | | | |
| 170 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | 12/17/31 JJ |
| Quality Control | | | | | | | | | |

U12-0730

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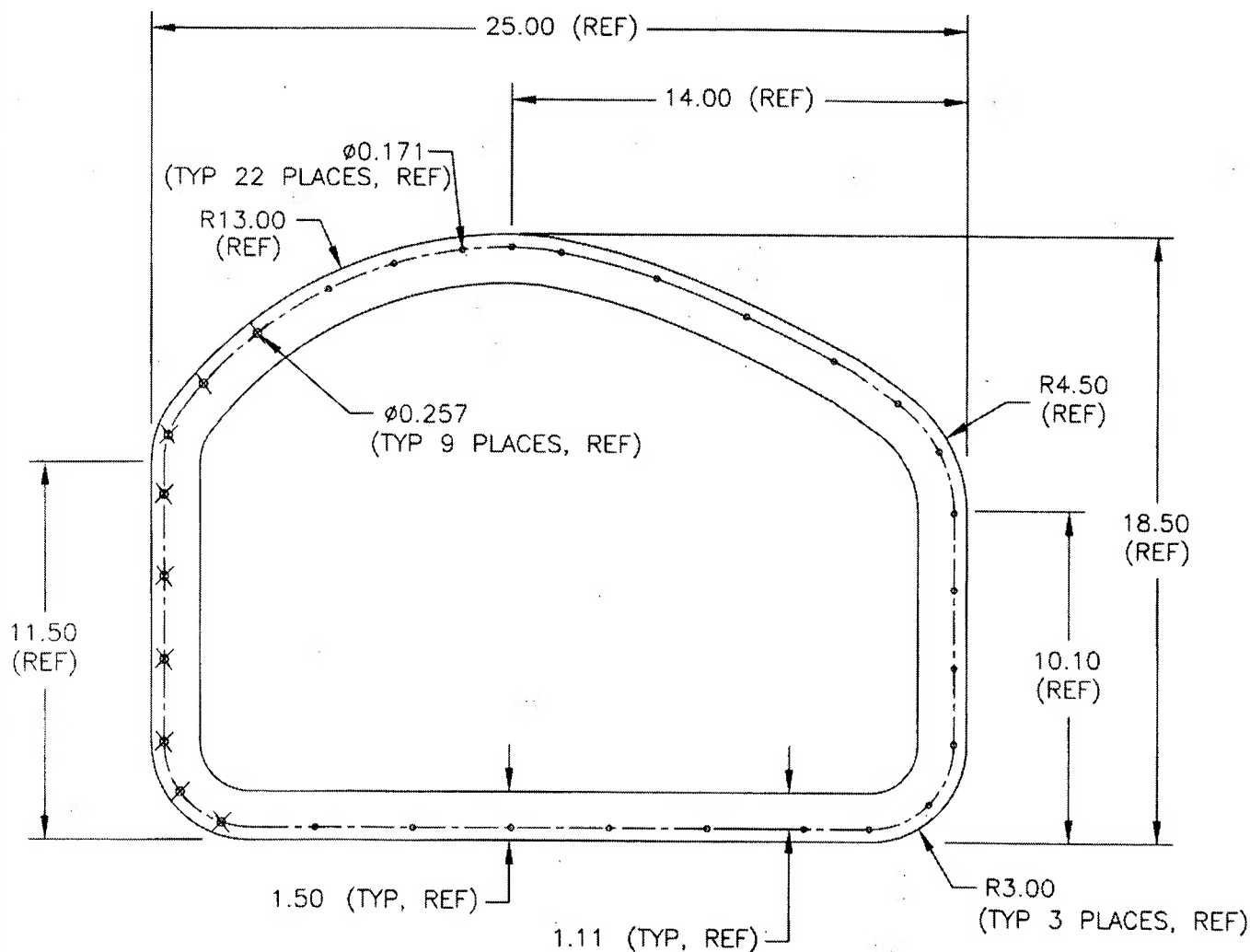
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|------------------|----------------|---|------------------------|
| DESIGN CP | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED H | APPROVED H | DRAWING NO. D2956 | REV. C SHEET 1 OF 1 |
| DATE 01.06.04 | | TITLE WINDOW FRAME | SCALE 1:5 |
| A | 00.01.20 | NEW ISSUE | |
| B | 00.02.23 | Ø0.141 HOLES WERE Ø0.128 (NCR 407) | |
| C | 01.06.04 | REMOVE Ø0.141 HOLES | |

RELEASED
01.06.05



D2956 FLAT PATTERN

MACHINE PER DRAWING FILE "D2956-C1.DWG"

CHECK HOLES PER TEMPLATE DT8437

BEND PER TEMPLATE DT8567

MATERIAL: 5052-H34 (QQ-A-250/8) SHEET 0.040 THICK

FINISH: POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 8198/ML5
12/07/11

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Dart Aerospace Ltd

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